

Date: Thursday, 9/14/2006 7:28:25 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : COVER PLATE ASSEMBLY, RH
 Job Number : 28555
 Estimate Number : 12302
 P.O. Number : *N/A* Part Number : D3467048
 This Issue : 9/14/2006 S.O. No. : *N/A* Drawing Number : D3467 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : SMALL /MED FAB Drawing Revision : B
 Previous Run : 26950 Material : *N/A*
 Due Date : 10/6/2006 Qty: *6* Um: Each
 Written By :
 Checked & Approved By : *06 09 14*
 Comment : Est Rev: A New Issue 06-04-24 EC
 Est Rev: B As per Rev B 06-05-24 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34672 COVER PLATE RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D3467-2 Shourd Plate *B2C 480*

MF. 06/08/18. (6)

2.0 D34677 SEAL STRIP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D3467-7 Doubler *B 26983*

MF. 06/09/18. (6)

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3467

2-Spot Weld as per Dwg D3467 and Dart QSI 004

3-Identify as D3467-048

MF. 06/09/18 (6)

4.0 QC5/11 INSPECT WORK/INSPECT SPOT WELD



Comment: INSPECT WORK/INSPECT SPOT WELD

SB 06/09/18 (C)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/09/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 7:28:25 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER PLATE ASSEMBLY, RH

Job Number: 28555

Part Number: D3467048

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 351

JS
05/06/09/19 (6)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SP (6) *06/09/19*

Job Completion



u *06/09/19*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

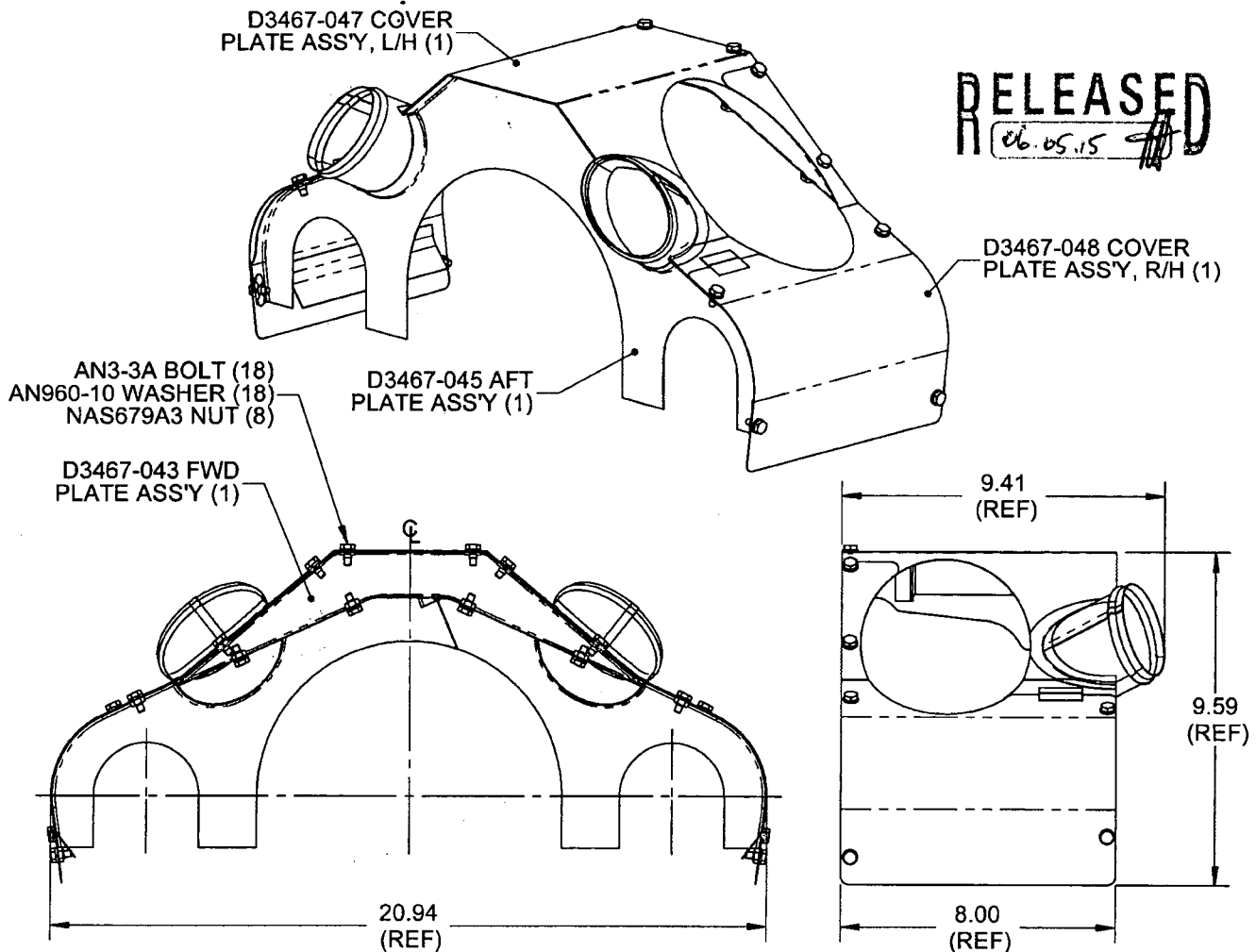
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3467	REV. B SHEET 1 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:5
A	05.12.07	NEW ISSUE	
B	06.05.15	Ø0.250 & Ø0.203 WERE Ø0.194 ; UPDATED D3467-9F/-15F	



D3467-041 SHROUD ASSEMBLY

NOTES:

- 1) IDENTIFY WITH DART P/N D3467-041 USING FINE POINT PERMANENT INK MARKER
- 2) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

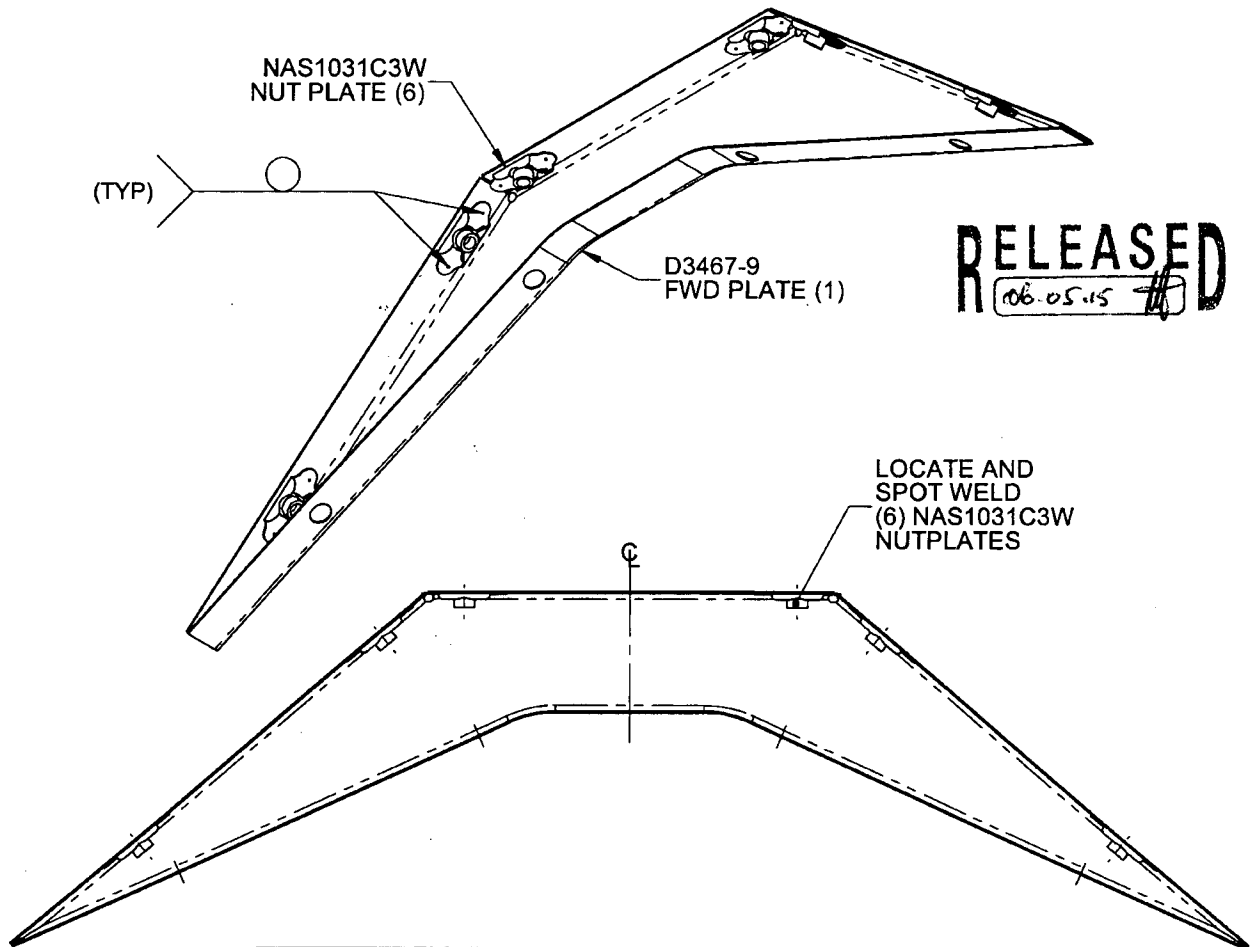
QTY -041	P/N	DESCRIPTION
X	D3467-041	SHROUD ASSEMBLY
1	D3467-043	FWD PLATE ASSEMBLY
1	D3467-045	AFT PLATE ASSEMBLY
1	D3467-047	COVER PLATE ASSEMBLY, L/H
1	D3467-048	COVER PLATE ASSEMBLY, R/H
18	AN3-3A	BOLT
18	AN960-10	WASHER
8	NAS679A3	NUT

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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2



QTY -043	P/N	DESCRIPTION
X	D3467-043	FWD PLATE ASSEMBLY
1	D3467-9	FWD PLATE
6	NAS1031C3W	NUT PLATE

D3467-043 FWD PLATE ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED NO.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

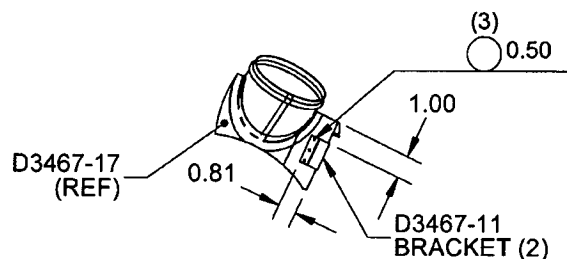
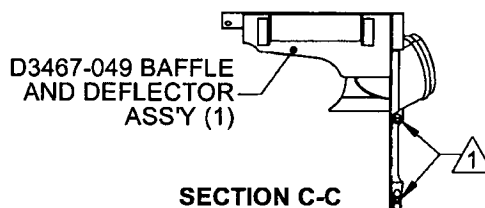
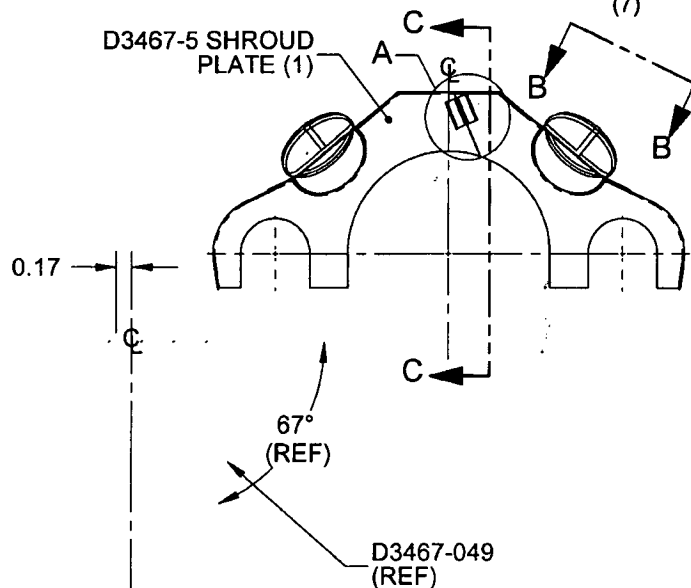
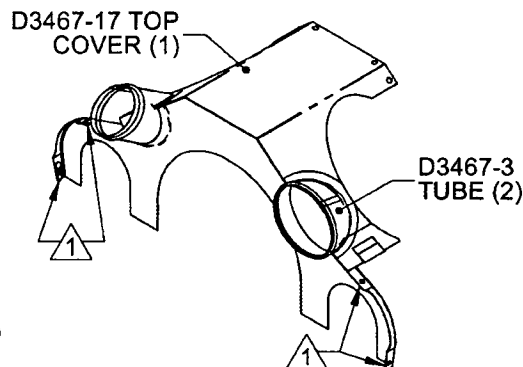
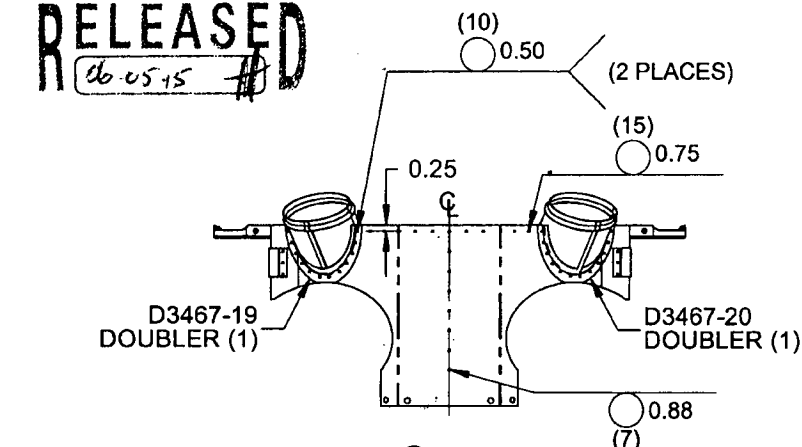
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:8

RELEASED
06-05-15

VIEW B-B: WELDING D3467-11
D3467-047 NOT SHOWN FOR CLARITY
(2 PLACES)

D3467-045 AFT PLATE ASSEMBLY

NOTES:

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -045	P/N	DESCRIPTION
X	D3467-045	AFT PLATE ASSEMBLY
1	D3467-049	BAFFLE AND DEFLECTOR ASSEMBLY
2	D3467-3	TUBE
1	D3467-5	SHROUD PLATE
2	D3467-11	BRACKET
1	D3467-17	TOP COVER
1	D3467-19	DOUBLER
1	D3467-20	DOUBLER
4	NAS1031C3W	NUT PLATE

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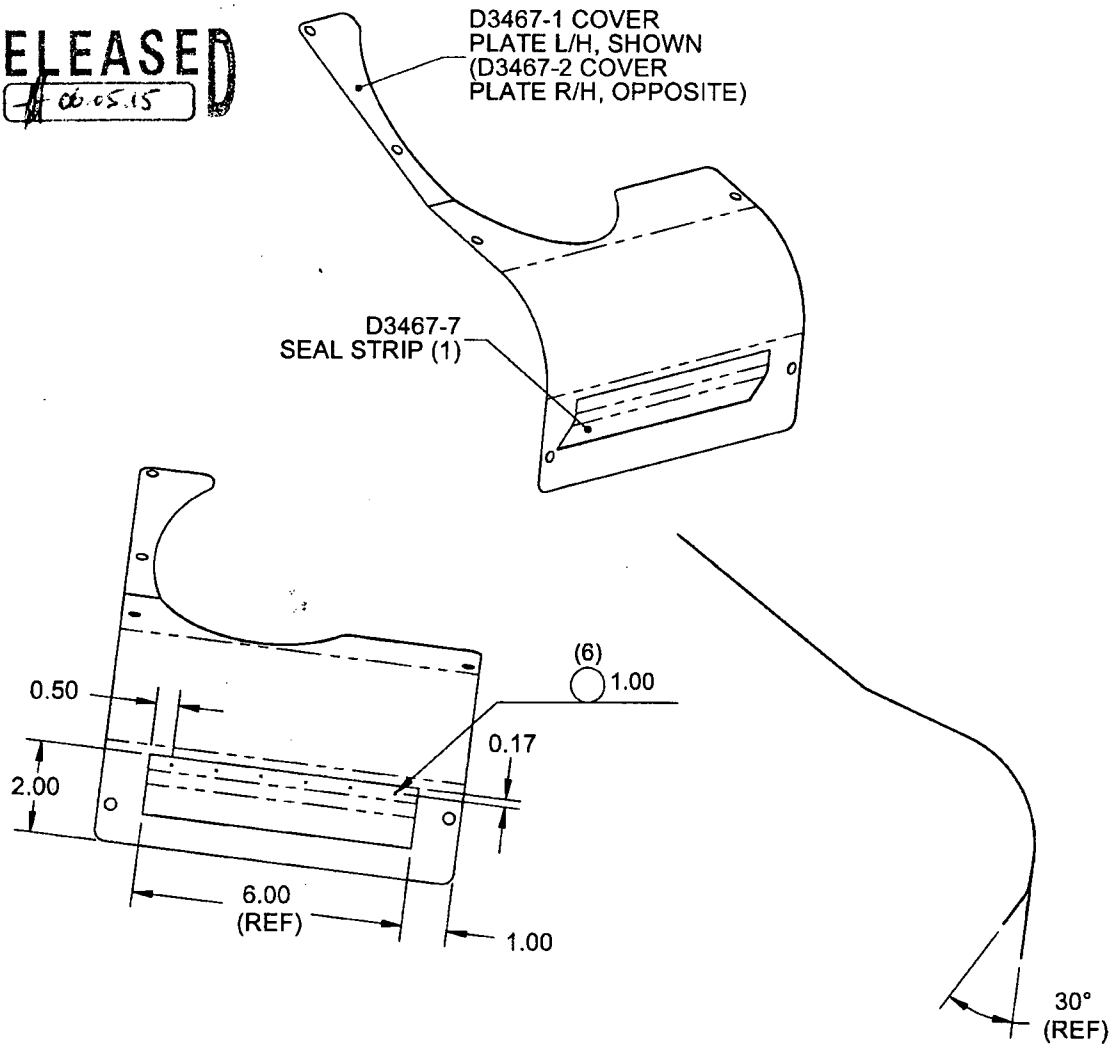
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4

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06.05.15



D3467-047 COVER PLATE ASS'Y L/H, SHOWN
D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -047	QTY -048	P/N	DESCRIPTION
X		D3467-047	COVER PLATE ASSEMBLY, L/H
	X	D3467-048	COVER PLATE ASSEMBLY, R/H
1		D3467-1	COVER PLATE, L/H
	1	D3467-2	COVER PLATE, R/H
1	1	D3467-7	SEAL STRIP

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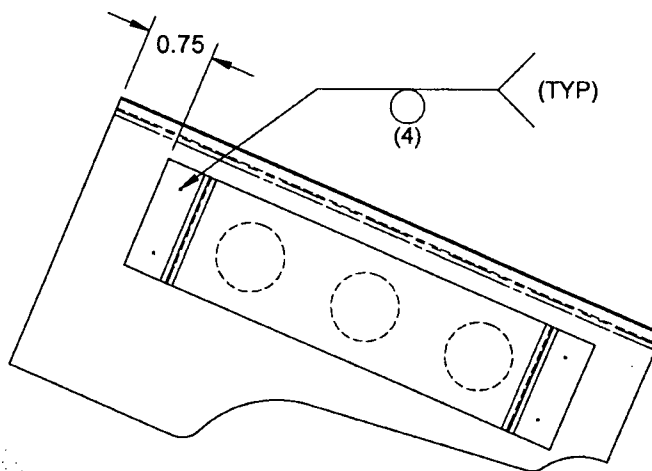
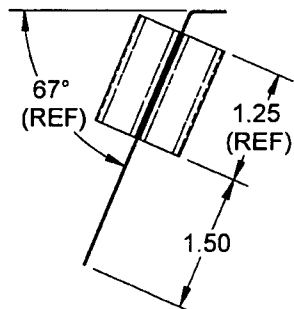
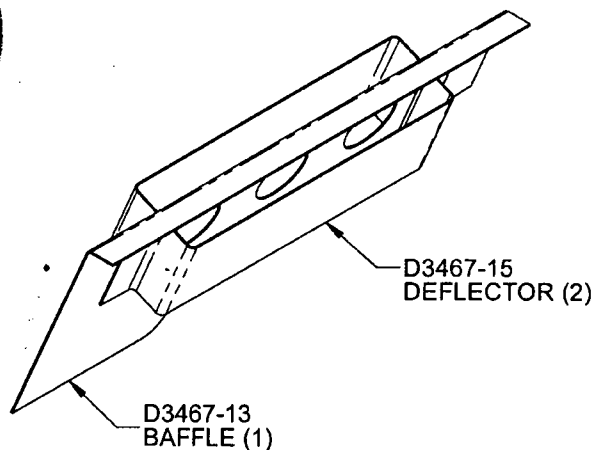
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D3467-049 BAFFLE & DEFLECTOR ASSEMBLY

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NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

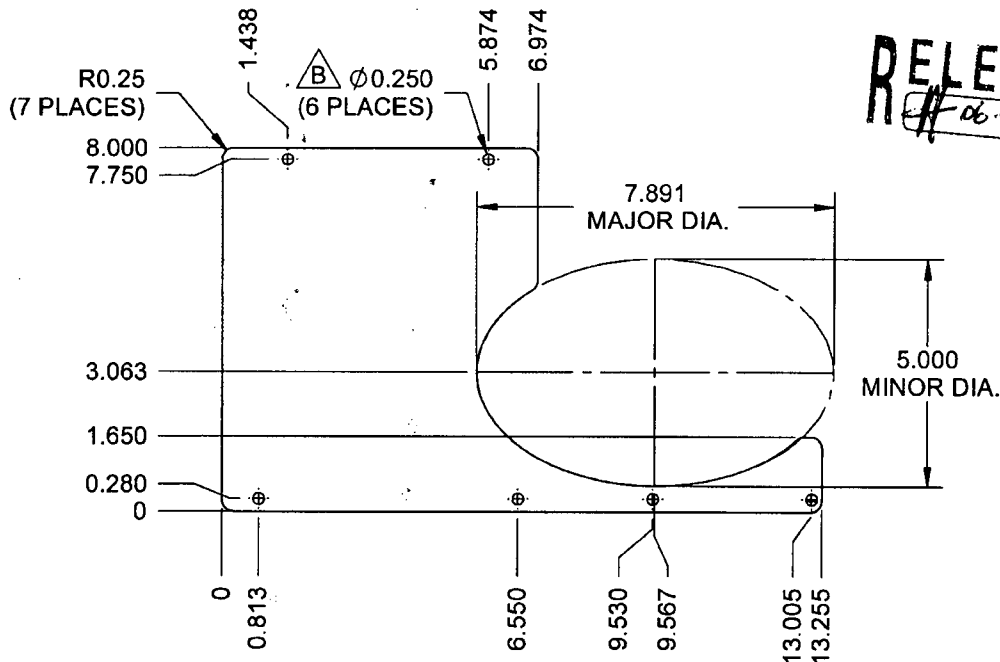
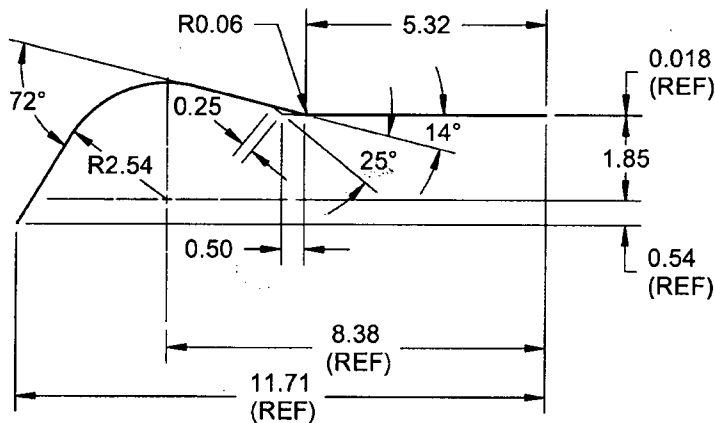
QTY -049	P/N	DESCRIPTION
	D3467-049	BAFFLE & DEFLECTOR ASSEMBLY
1	D3467-13	BAFFLE
2	D3467-15	DEFLECTOR

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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4

**D3467-1F COVER PLATE FLAT PATTERN****D3467-1 L/H COVER PLATE
D3467-2 R/H COVER PLATE (OPPOSITE)****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

**D3467-1 L/H COVER PLATE ISOMETRIC VIEW.
D3467-2 R/H COVER PLATE (OPPOSITE)**

SCALE 1:8 SHOP COPY

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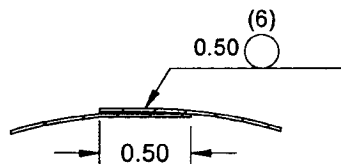
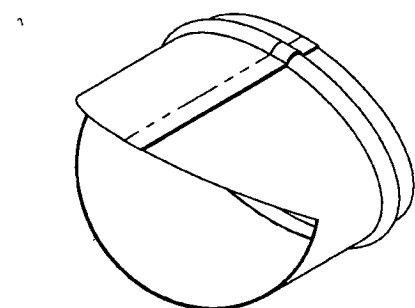
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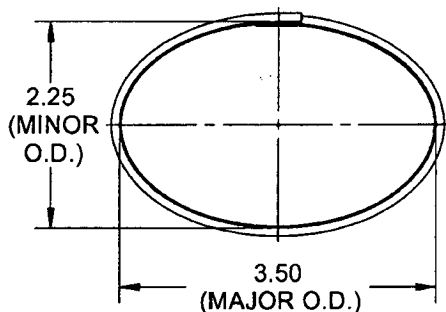


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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

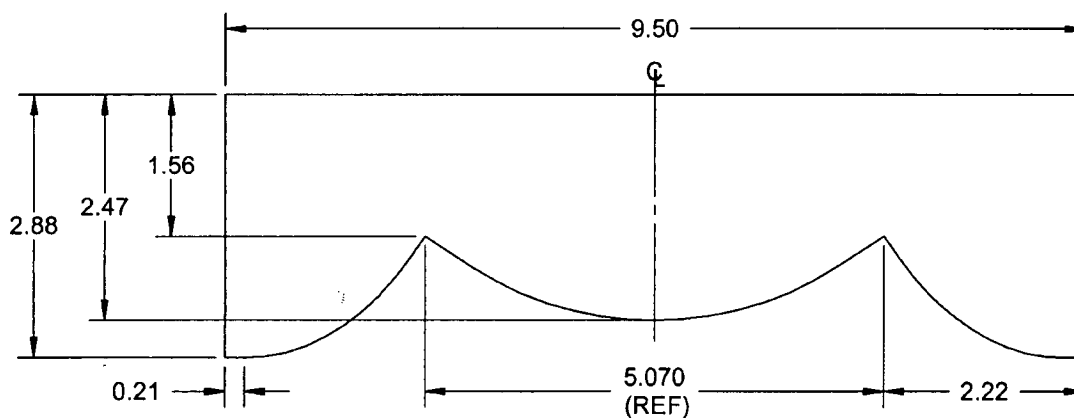
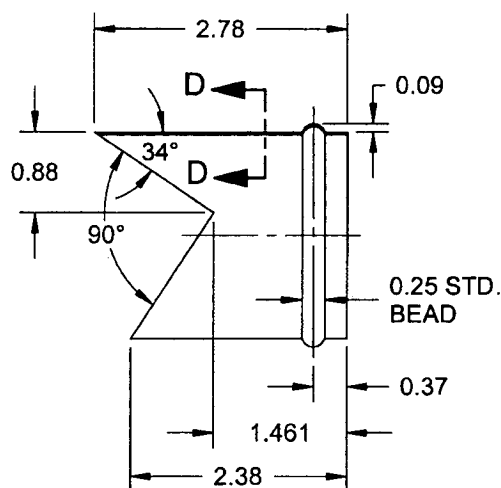
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06.05.15



SECTION D-D
SCALE 1:1



D3467-3 TUBE DETAIL



D3467-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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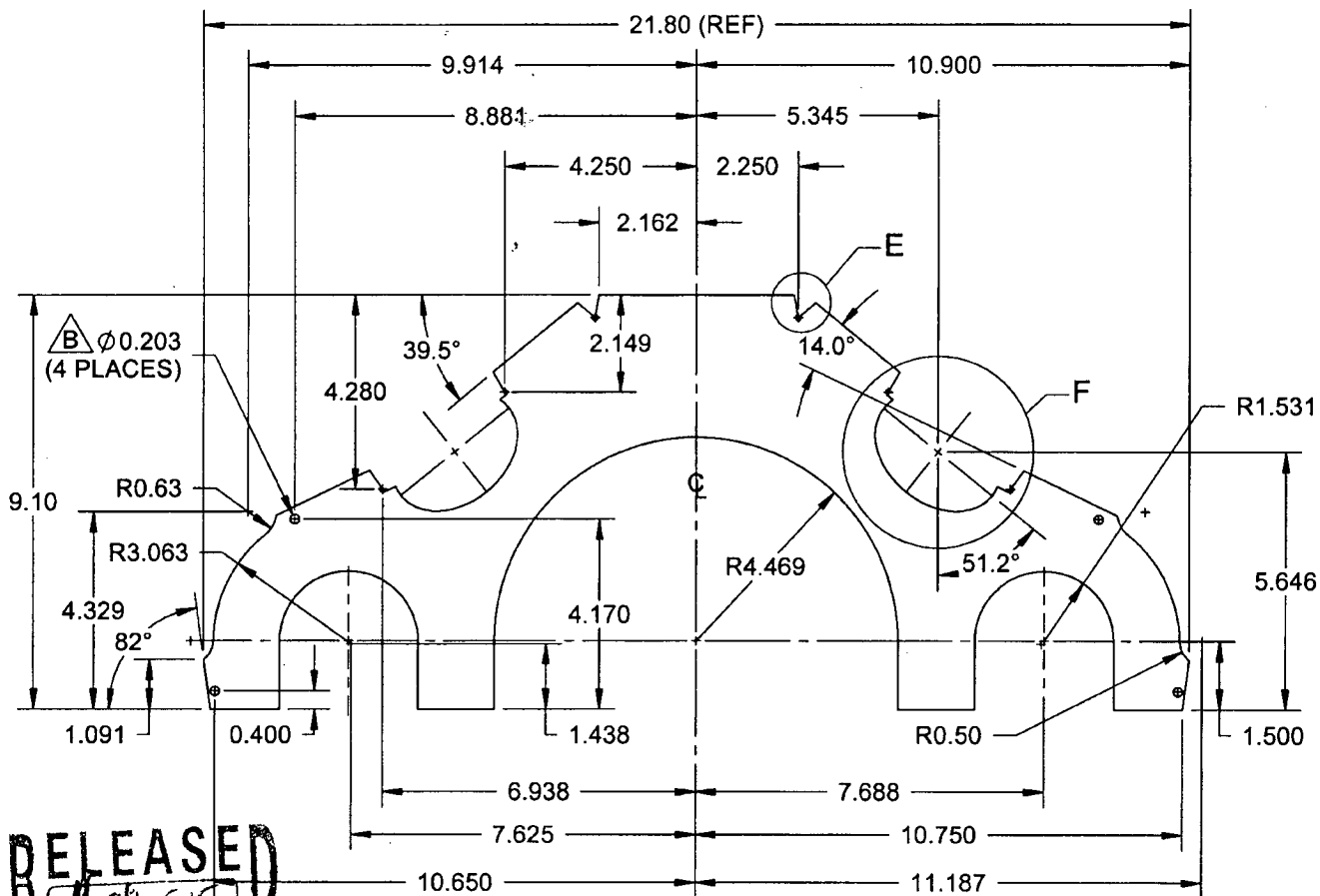
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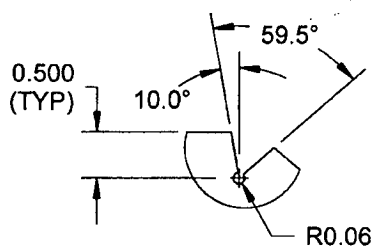
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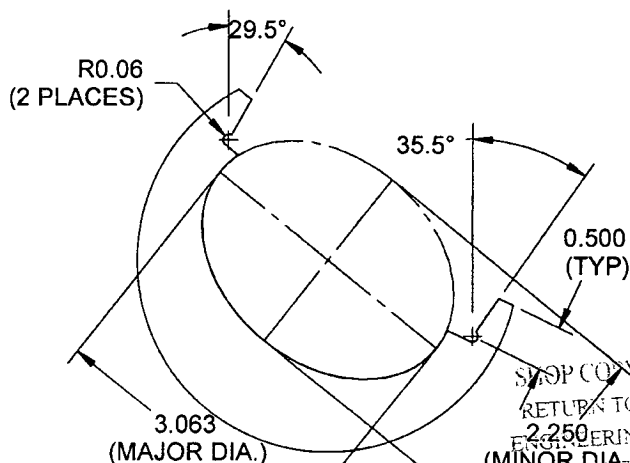
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:8



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06-05-15



DETAIL E
SCALE 1:2



DETAIL F
SCALE 1:2

D3467-5F AFT PLATE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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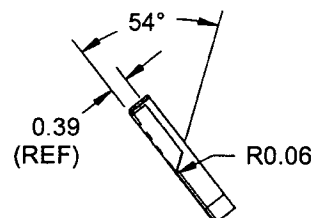
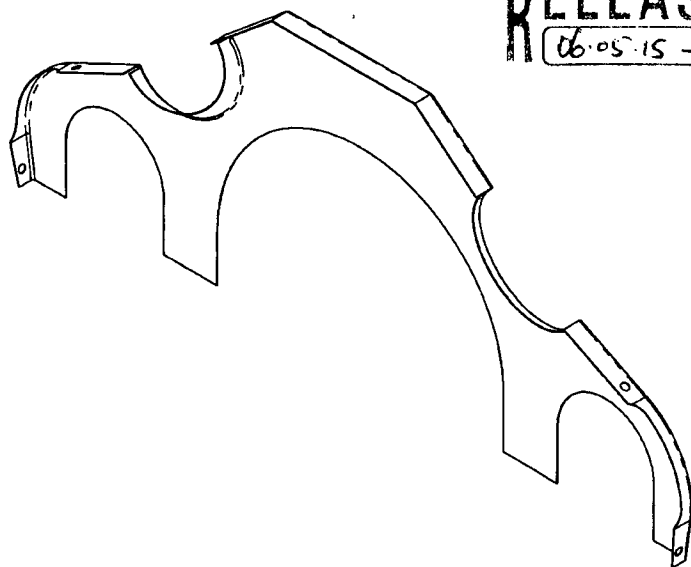
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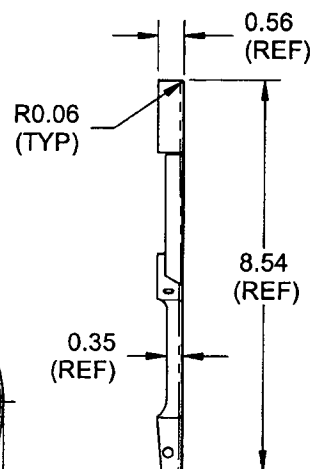
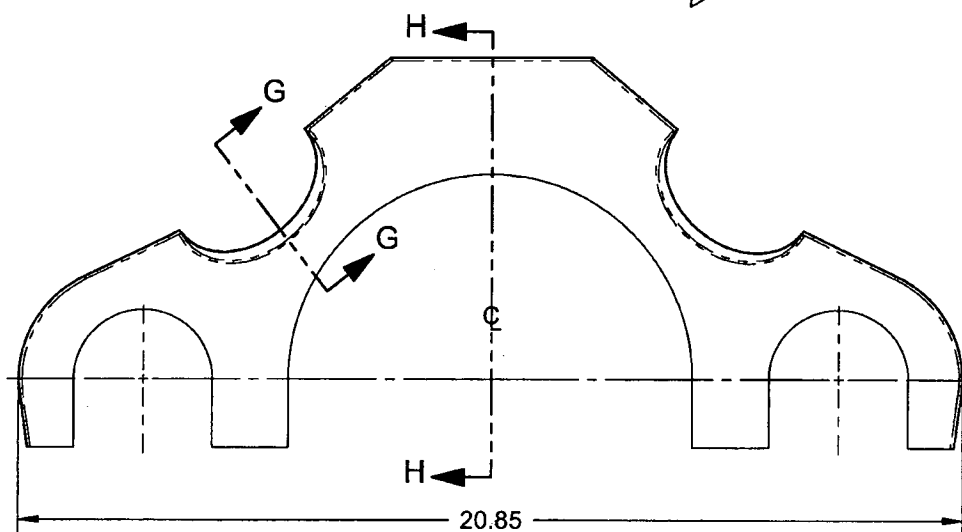
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4

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06.05.15



SECTION G-G



SECTION H-H

D3467-5 AFT PLATE BENDING DETAIL

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

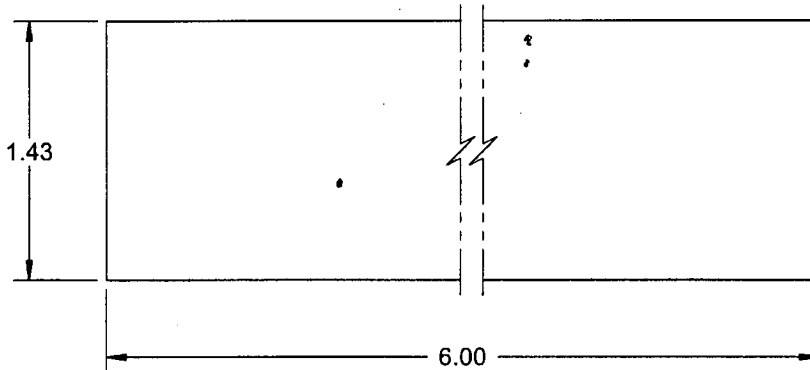
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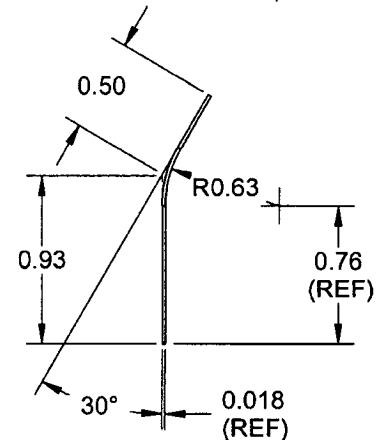
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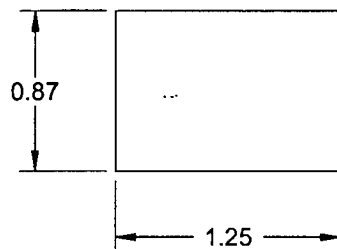
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:1

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06-05-15

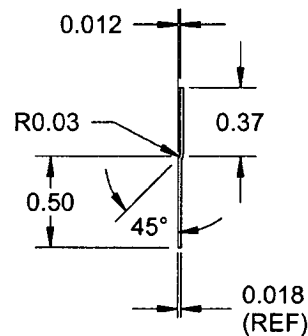
D3467-7F SEAL STRIP
FLAT PATTERN



D3467-7 SEAL STRIP
BENDING DETAIL



D3467-11F BRACKET
FLAT PATTERN



D3467-11 BRACKET
JOGGLE DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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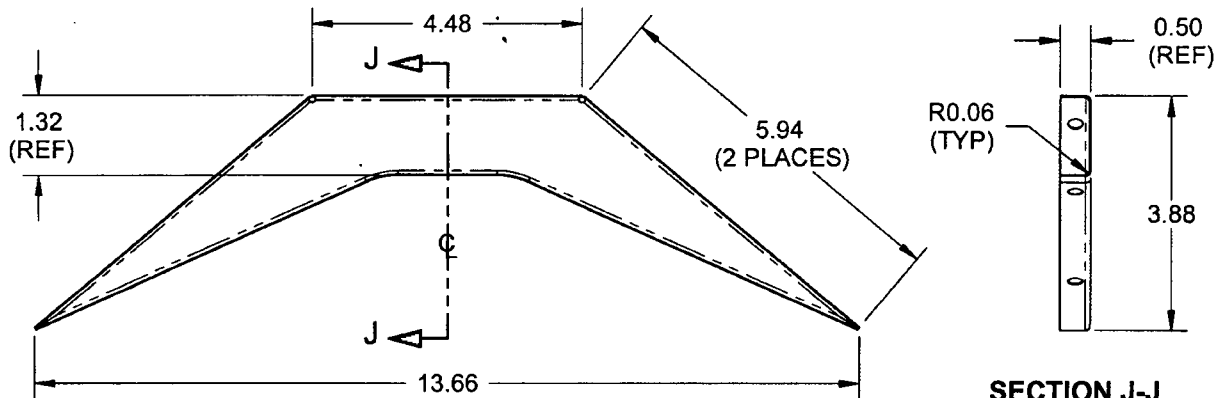
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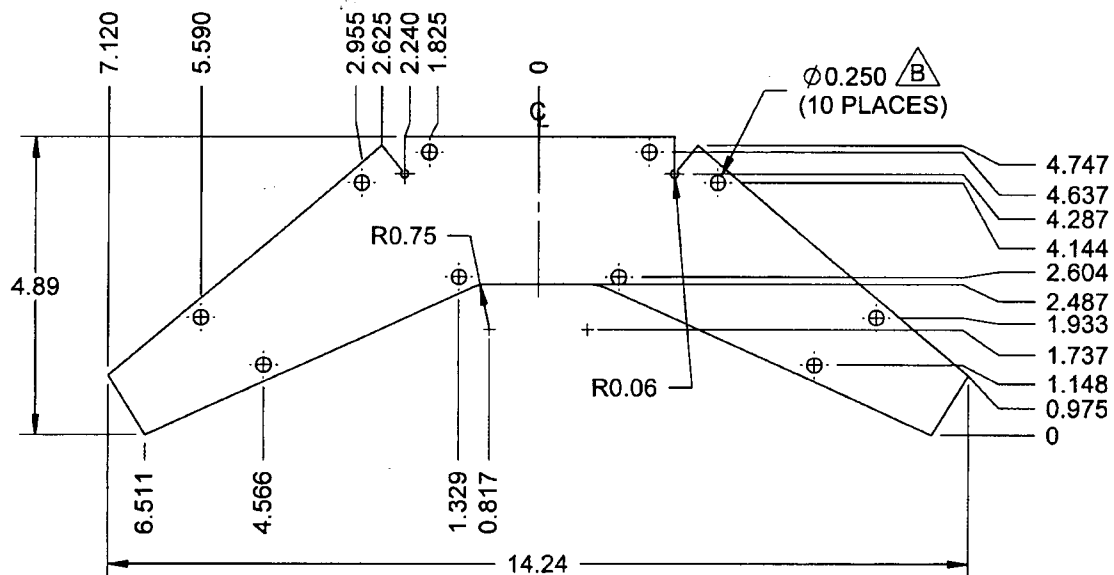


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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3467	REV. B SHEET 11 OF 15
DATE 06.05.15	TITLE SHROUD ASSEMBLY		SCALE 1:3

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06.05.15



D3467-9 FWD PLATE BENDING DETAIL



D3467-9F FWD PLATE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

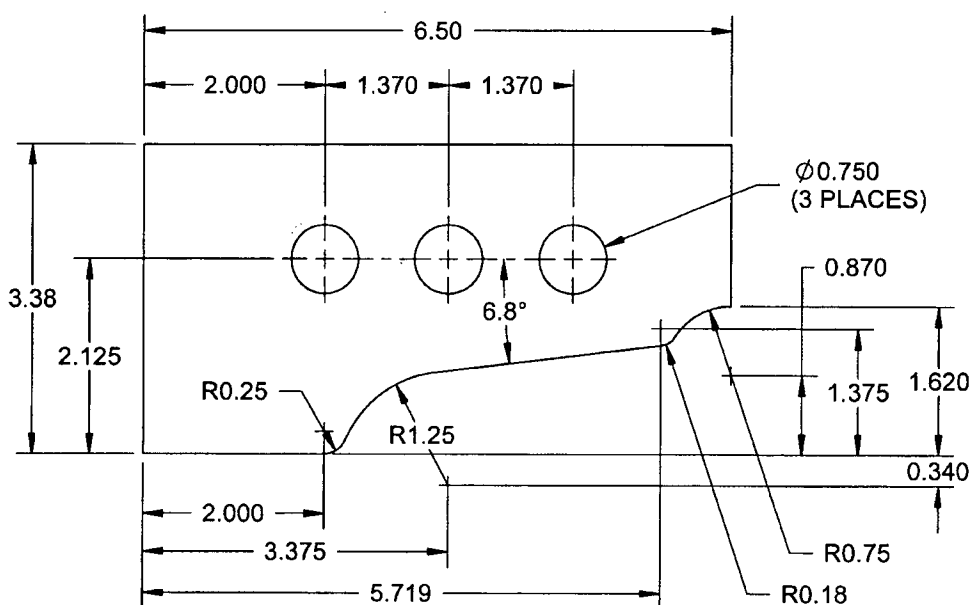
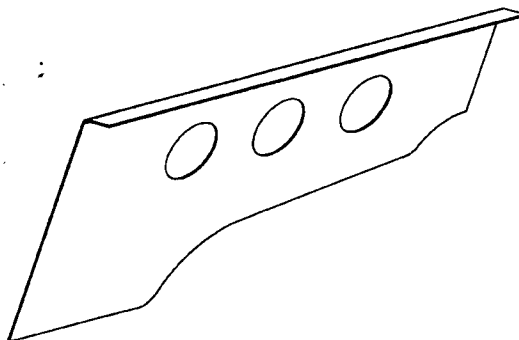
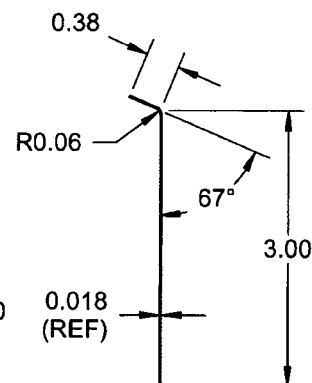
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3467	REV. B SHEET 12 OF 15
DATE 06.05.15	TITLE SHROUD ASSEMBLY		SCALE 1:2

RELEASED
[Stamp]**D3467-13F BAFFLE
FLAT PATTERN****D3467-13 BAFFLE
BEND DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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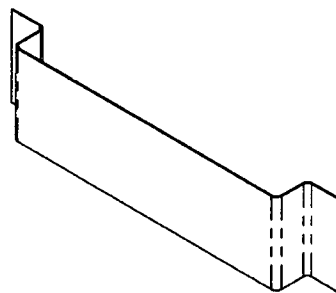
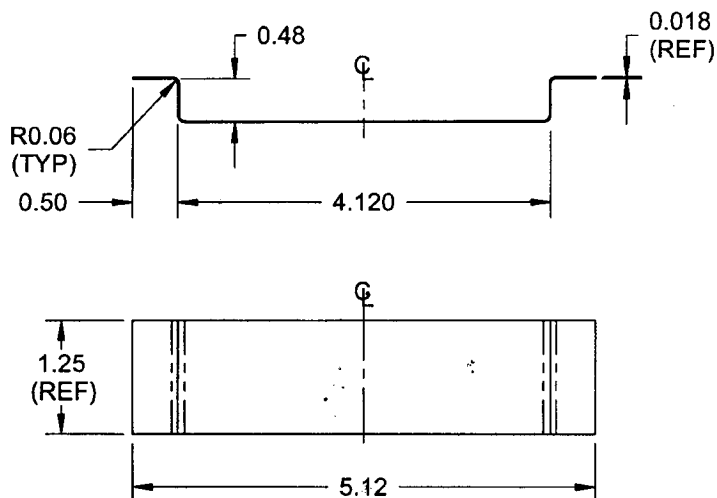
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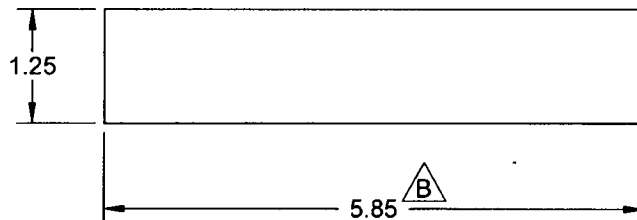


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3467	REV. B SHEET 13 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

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[Stamp]



D3467-15 DEFLECTOR BENDING DETAIL



D3467-15F DEFLECTOR FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

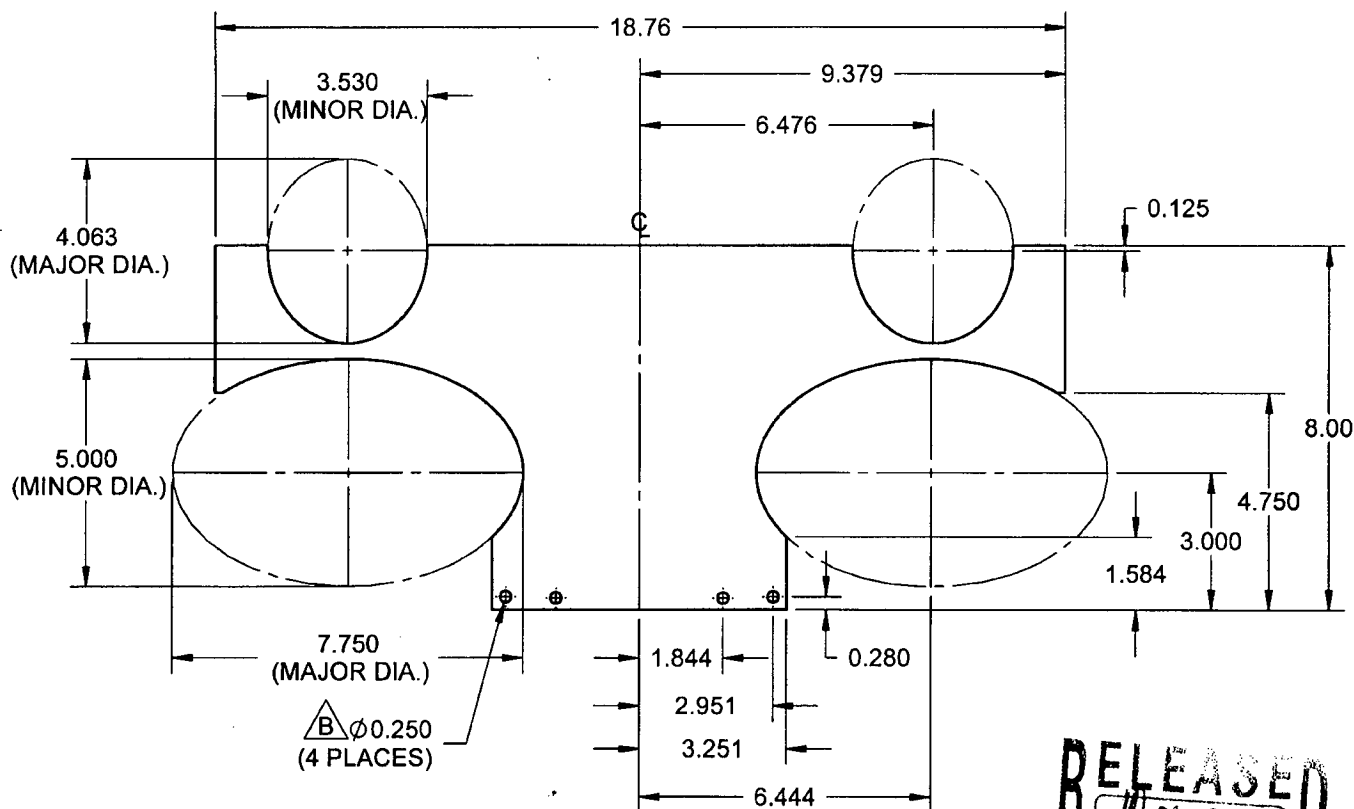
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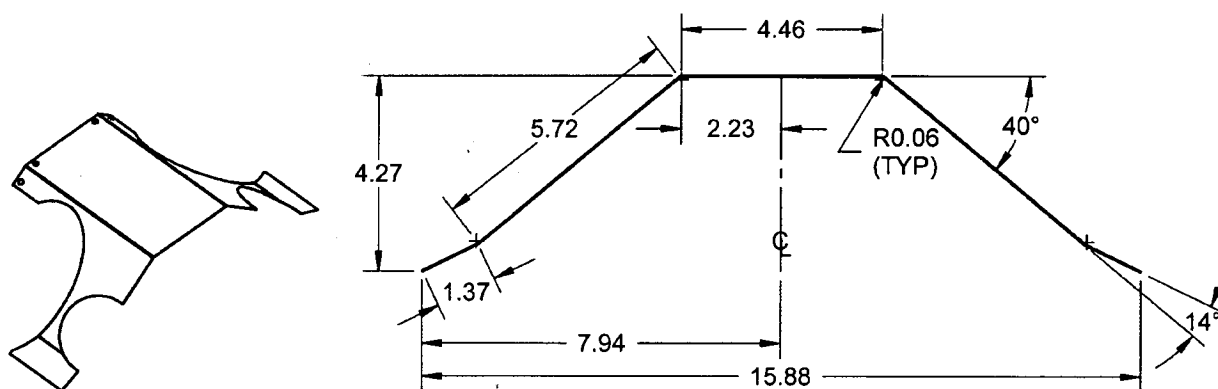


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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4



D3467-17F TOP COVER FLAT PATTERN

RELEASED
[Stamp]



D3467-17 TOP COVER BENDING DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

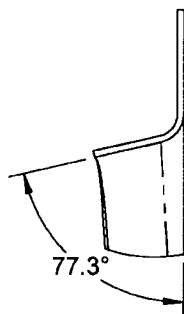
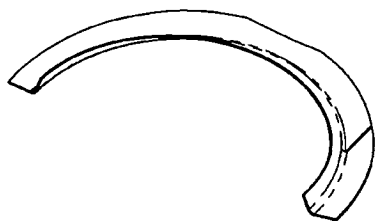
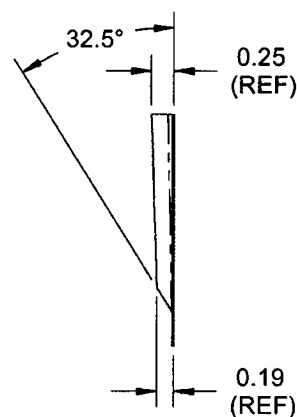
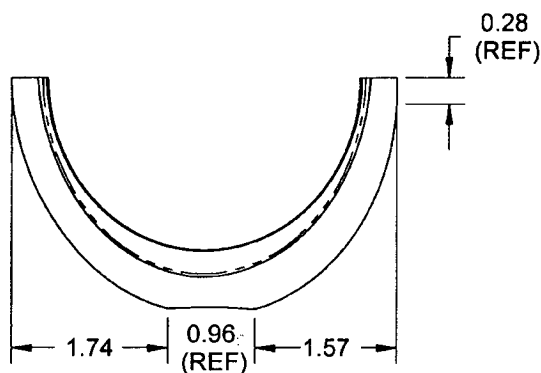
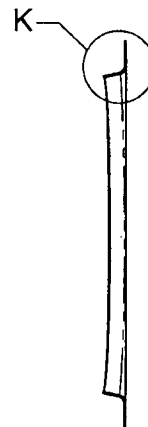
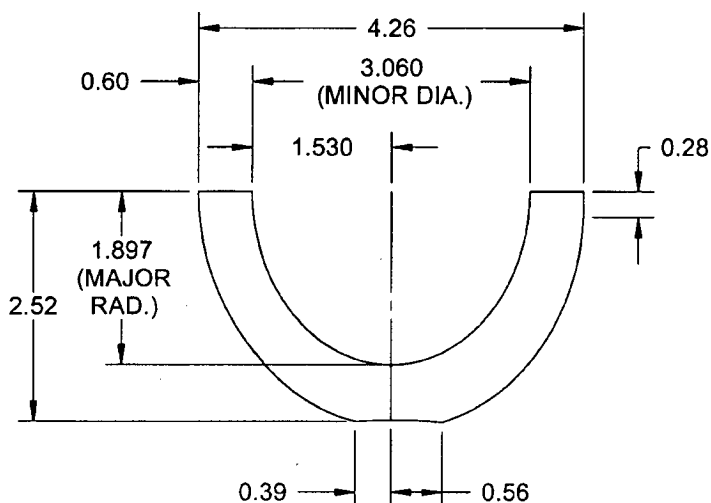
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DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

RELEASED
06 vs 5**DETAIL K**
SCALE 1:2**D3467-19 DOUBLER, L/H SHOWN**
D3467-20 DOUBLER, R/H OPPOSITESHOP COPY
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NO. 28555**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 5

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Sylvie Boucher
Joint Welding Procedure Spot weld
Part number and Job number 3467048 / B28555

TEST WELDS REQUIRED

BASE METAL S.S. WELDING PROCESS Spot weld
Penetration Complete ☒ Partial ☐ Single Weld ☒ Double Weld ☐
Current AC ☐ DC ☒ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into _____ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☐ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/09/19 Qualifier David Duval

